

Date: Tuesday, 19/05/2009 11:36:09 AM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET  
 Job Number : 47987  
 Estimate Number : 13940  
 P.O. Number :  
 This Issue : 19/05/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D3945041  
 First Issue : // Type : SMALL /MED FAB Drawing Number : D3945 PREL PROTO 09.05.19  
 Drawing Revision : PREL  
 Material :  
 Due Date : 20/05/2009 Qty: 4 Um: Each  
 Written By :  
 Checked & Approved By : MF 09-05-19  
 Comment : Est Rev:A New Issue 09-05-16 JLM Verified By:DD

## Additional Product

Job Number:



PROTOTYPE

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S050 6061-T6 .050 Sheet



Comment: Qty.: 0.0132 sf(s)/Unit Total : 0.0529 sf(s)

6061-T6 .050 Sheet

BATCH: 104186 B9-5-19

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3945

Dwg Rev: PROTO B9-5-19

Prog Rev: TYPE

2-Deburr if necessary

SD 09/05/19

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

UP 09.05.09 6

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 COUNTERSINK AS PER DWG

09/05/21 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: BRACKET

Job Number: 47987

Part Number: D3945041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg

SB 02/05/21 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

CP 09.05.21

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

NIA CP 09.05.21

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_

NIA CP 09.05.21

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

NIA CP 09.05.21

11.0

MS21059L3

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut Plate

BATCH: 1109962

CP 09/05/21

12.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

BATCH: 117681

CP 09/05/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
INSTALL NUT PLATES AS PER DWG

*CP 09/05/21 (6)*

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*CP 05.05.21*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock  
Location: \_\_\_\_\_

*CP 05.05.21*  
**ENG USE ONLY**

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*CP 09.05.21 Polytype*

Job Completion



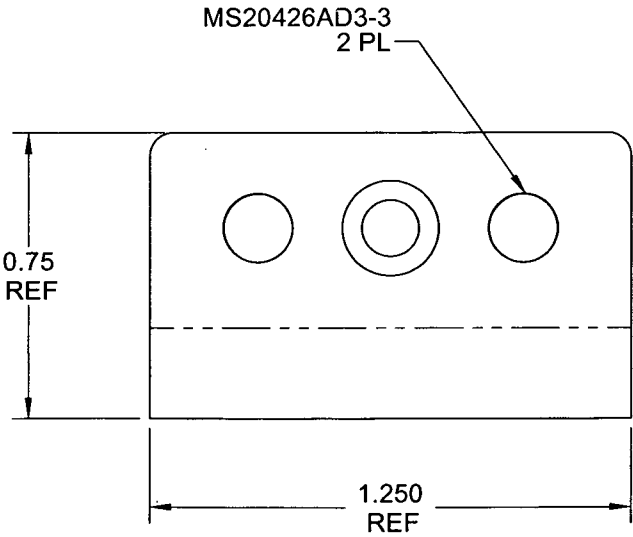
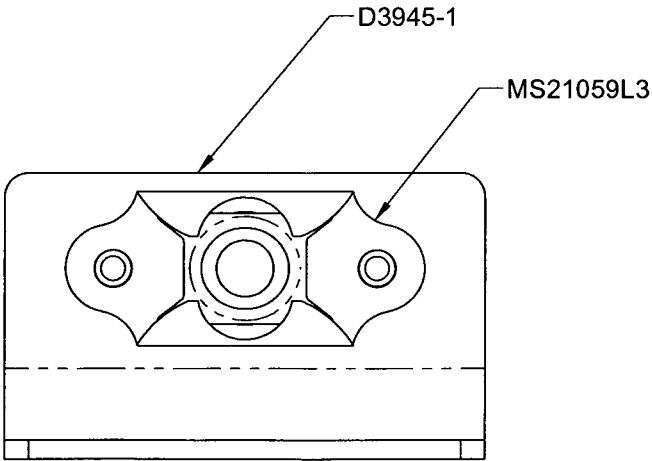
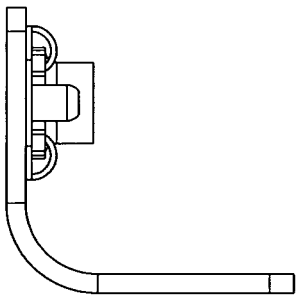
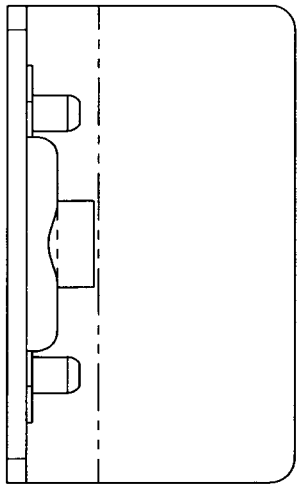
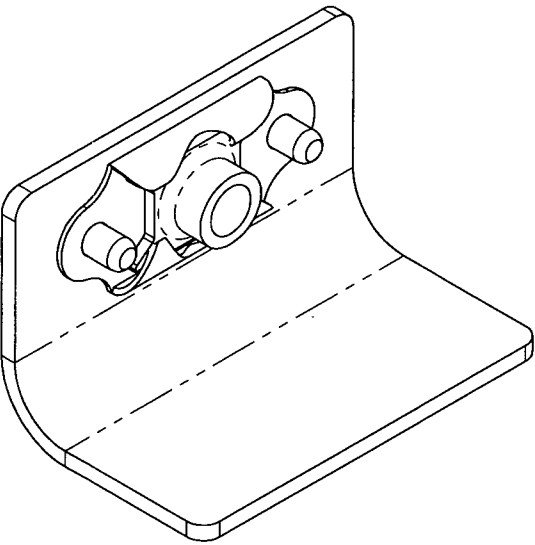
*MF*  
*09-06-05*  
*00280A*



PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3945-041	BRACKET
2	1	D3945-1	BRACKET
3	1	MS21059L3	NUTPLATE
4	2	MS20426AD3-3	RIVET

PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09.05.19



D3945-041 BRACKET

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3945-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3945	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

D

C

B

A

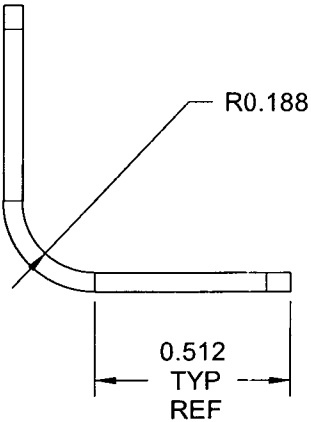
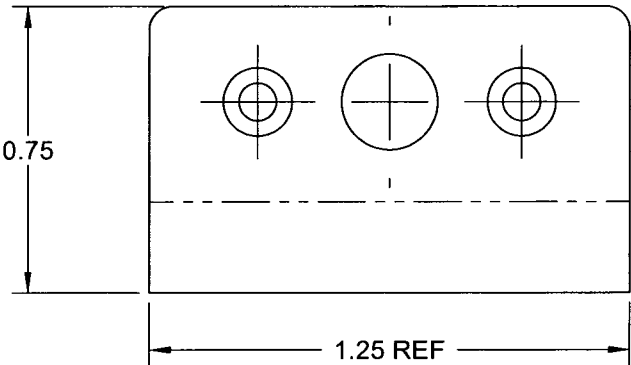
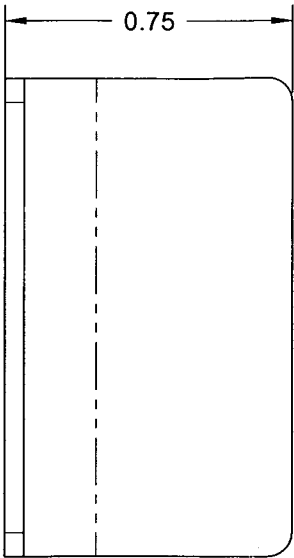
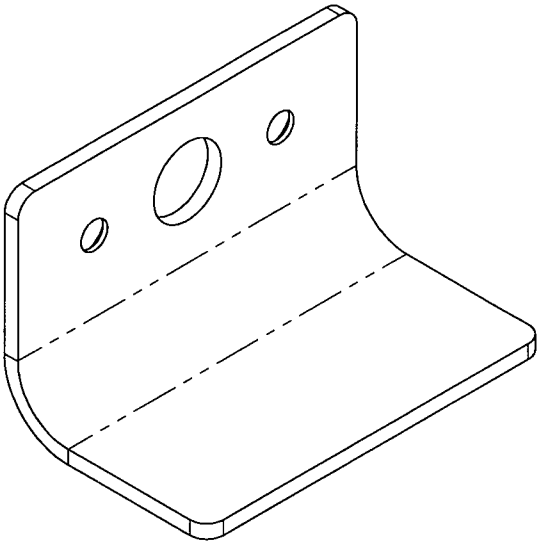
D

C

B

A

PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
97 09.05.19



**D3945-1 BRACKET**

- NOTES:
- 1) MATERIAL: MAKE FROM D3945-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 004 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3945</b>	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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8 7 6 5 4 3 2 1



